



Dart Aerospace Ltd.  
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K6A 1K7  
Canada

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**RBE703A94-1130-01-23**

**Job Sheet 193098**

**Part No:** RBE703A94-1130-01-23

**Job Qty:** 20 pcs

**Part Name:** Deflection Clip Assembly

**Part Weight:** 0 lbs

**Status:** New

**Priority:** Medium

**Job Created:** 4/8/19

**Job Tracking No:**

**Due Date:** 5/6/19

**Created By:** Marie Lajeunesse

**Type:** SOLD

**Description:**

**Note:** DWG RBE703A94-1130-01 Rev K IPP Rev.A 17.08.09 New issue DP Verify DD/IPP Rev B 17.11.30 DWG Rev B DP Verify DD

**Ship Via:**

### Bill of Materials

### Job Routing

| Op No | Operation                   | Qty    | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |           | Sign-off |
|-------|-----------------------------|--------|------------|----------|-----------|---------|-----------------------|-----------|----------|
|       |                             |        |            |          | Setup Hrs | Run Hrs | Workcenter / Supplier | Lead Time |          |
| 110   | Small Fab - 1               | 20 pcs | 5/6/19     |          | 0.00      | 20.00   | Small Fab - 1         |           | DAS      |
|       |                             |        |            |          |           |         | Small Fab - 2         |           | 71       |
|       |                             |        |            |          |           |         | Small Fab - 3         |           | 9-89     |
|       |                             |        |            |          |           |         | Small Fab - 4         |           |          |
|       |                             |        |            |          |           |         | Small Fab - 5         |           | 19-5-6   |
|       |                             |        |            |          |           |         | Small Fab - 6         |           |          |
|       |                             |        |            |          |           |         | Small Fab - 7         |           |          |
| 120   | QC 5                        | 20 pcs | 5/6/19     |          | 0.00      | 0.00    | QC 5 - 10             |           |          |
|       |                             |        |            |          |           |         | QC 5 - 12             |           |          |
|       |                             |        |            |          |           |         | QC 5 - 17             |           |          |
|       |                             |        |            |          |           |         | QC 5 - 18             |           |          |
|       |                             |        |            |          |           |         | QC 5 - 19             |           |          |
|       |                             |        |            |          |           |         | QC 5 - 22             |           |          |
|       |                             |        |            |          |           |         | QC 5 - 24             |           |          |
|       |                             |        |            |          |           |         | QC 5 - 3              |           |          |
|       |                             |        |            |          |           |         | QC 5 - 43             |           |          |
|       |                             |        |            |          |           |         | QC 5 - 49             |           |          |
|       |                             |        |            |          |           |         | QC 5 - 51             |           |          |
|       |                             |        |            |          |           |         | QC 5 - 58             |           |          |
|       |                             |        |            |          |           |         | QC 5 - 68             |           |          |
|       |                             |        |            |          |           |         | QC 5 - 9              |           |          |
|       |                             |        |            |          |           |         | QC 5 - 50             |           |          |
|       |                             |        |            |          |           |         | QC 5 - 30             |           |          |
|       |                             |        |            |          |           |         | QC 5 - 40             |           |          |
| 130   | Packaging 3-1 - Stock - B4B | 20 pcs | 5/6/19     |          | 0.00      | 0.00    | Packaging 3 - 1 - B4B |           | DAS      |
|       |                             |        |            |          |           |         | Packaging 3 - 2 - B4B |           | 40       |
|       |                             |        |            |          |           |         | Packaging 3 - 3 - B4B |           | 9-89     |
|       |                             |        |            |          |           |         | Packaging 3 - 4 - B4B |           |          |
|       |                             |        |            |          |           |         | Packaging 3 - 5 - B4B |           |          |
|       |                             |        |            |          |           |         | Packaging 3 - 6 - B4B |           |          |



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**Container No:** S178120



**Part:** RBE703A94-1130-01-23

**Job No:** 193098

**Serial No/Batch:** S178120

**Revision:** k

**Inspector:**

**Exp Date:**

**Instructions:**

Date: 05/06/19

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|                |        |        |      |      |                        |               |
|----------------|--------|--------|------|------|------------------------|---------------|
|                |        |        |      |      | Packaging 3 - 7 - B4B  |               |
|                |        |        |      |      | Packaging 3 - 8 - B4B  |               |
|                |        |        |      |      | Packaging 3 - 9 - B4B  |               |
|                |        |        |      |      | Packaging 3 - 10 - B4B |               |
|                |        |        |      |      | Packaging 3 - 11 - B4B |               |
|                |        |        |      |      | Packaging 3 - 12 - B4B |               |
|                |        |        |      |      | Packaging 3 - 13 - B4B |               |
|                |        |        |      |      | Packaging 3 - 14 - B4B |               |
|                |        |        |      |      | Packaging 3 - 15 - B4B |               |
|                |        |        |      |      | Packaging 3 - 16 - B4B |               |
|                |        |        |      |      | Packaging 3 - 17 - B4B |               |
|                |        |        |      |      | Packaging 3 - 18 - B4B |               |
|                |        |        |      |      | Packaging 3 - 19 - B4B |               |
|                |        |        |      |      | Packaging 3 - 20 - B4B |               |
|                |        |        |      |      | Packaging 3 - 21 - B4B |               |
|                |        |        |      |      | Packaging 3 - 22 - B4B |               |
|                |        |        |      |      | Packaging 3 - 23 - B4B |               |
|                |        |        |      |      | Packaging 3 - 24 - B4B |               |
|                |        |        |      |      | Packaging 3 - 25 - B4B |               |
|                |        |        |      |      | Packaging 3 - 26 - B4B |               |
|                |        |        |      |      | Packaging 3 - 27 - B4B | GA133         |
|                |        |        |      |      | Packaging 3 - 28 - B4B | ✓ MAY 13 2019 |
|                |        |        |      |      | Packaging 3 - 29 - B4B |               |
|                |        |        |      |      | Packaging 3 - 30 - B4B |               |
|                |        |        |      |      | Packaging 3 - 31 - B4B |               |
|                |        |        |      |      | Packaging 3 - 32 - B4B |               |
|                |        |        |      |      | Packaging 3 - 33 - B4B |               |
|                |        |        |      |      | Packaging 3 - 34 - B4B |               |
|                |        |        |      |      | Packaging 3 - 35 - B4B |               |
|                |        |        |      |      | Packaging 3 - 36 - B4B |               |
| 140 QC 21 - SA | 20 pcs | 5/6/19 | 0.00 | 0.00 | QC 21 - SA - 21        |               |
|                |        |        |      |      | QC 21 - SA - 70        | ✓ MAY 13 2019 |
|                |        |        |      |      | QC 21 - SA - 53        | 21            |

Part Op 110 - (Small Fab) 1-Assemble as per DWG. Sheet 9. 2-Apply Loctite to mating surfaces of item -33 and -27 -Loctite 263  
 Descriptions: B \_\_\_\_\_ Exp.; \_\_\_\_\_ \*\*\*Item -33 should not protrude past the surface of item -27\*\*\*

120 - (QC5- Inspect part completeness to step on W/O)

130 - (Identify as per dwg & Stock Location: \_\_\_\_\_)

140 - (QC21- Final Inspection - Work Order Release)

### Job BOM

| Part / Item          | Component Name                           | Quantity      | Operation         | Container        |
|----------------------|------------------------------------------|---------------|-------------------|------------------|
| 90353A214            | Pan Head Machine Screw M4 x 0.7mm x 12mm | 40 Ea (2 ea)  | 110-Small Fab - 1 | ✓ S172720        |
| 91595A155            | Dowel Pin 4mm x 12mm                     | 40 Ea (2 ea)  | 110-Small Fab - 1 | ✓ S091269        |
| 98296A882            | Slotted Spring Pin Ø1/8" X 7/8"          | 20 Ea (1 ea)  | 110-Small Fab - 1 | ✓ F1135414-34    |
| 98338A022            | Cotter Pin Ø3/64" X 1/2"                 | 40 Ea (2 ea)  | 110-Small Fab - 1 | ✓ S172680        |
| RBE703A94-1130-01-25 | Tab Adjuster Handle                      | 20 pcs (1 ea) | 110-Small Fab - 1 | ✓ S143905        |
| RBE703A94-1130-01-27 | Tab Adjuster Body                        | 20 pcs (1 ea) | 110-Small Fab - 1 | ✓ S146424/616777 |
| RBE703A94-1130-01-29 | Tab Adjuster Clamp                       | 20 pcs (1 ea) | 110-Small Fab - 1 | ✓ S142284        |
| RBE703A94-1130-01-31 | Tab Adjuster Gauge Plate                 | 20 pcs (1 ea) | 110-Small Fab - 1 | ✓ S146069        |
| RBE703A94-1130-01-33 | Adjuster                                 | 40 pcs (2 ea) | 110-Small Fab - 1 |                  |
| 6NF45/A              | Knurled Nut                              | 40 Ea (2 ea)  | 110-Small Fab - 1 | ✓ S172589        |

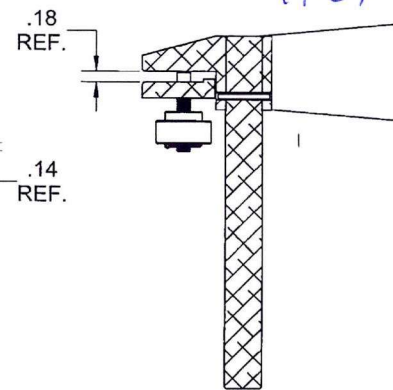
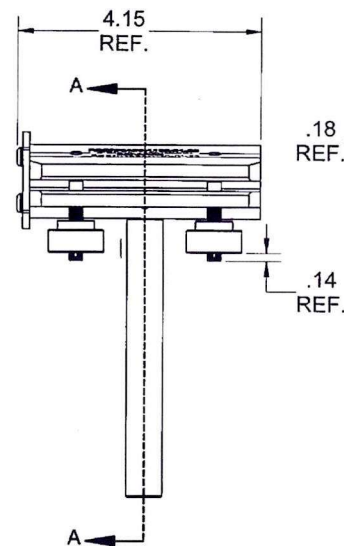
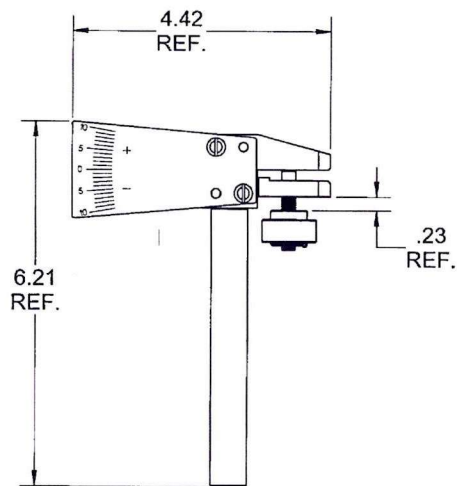
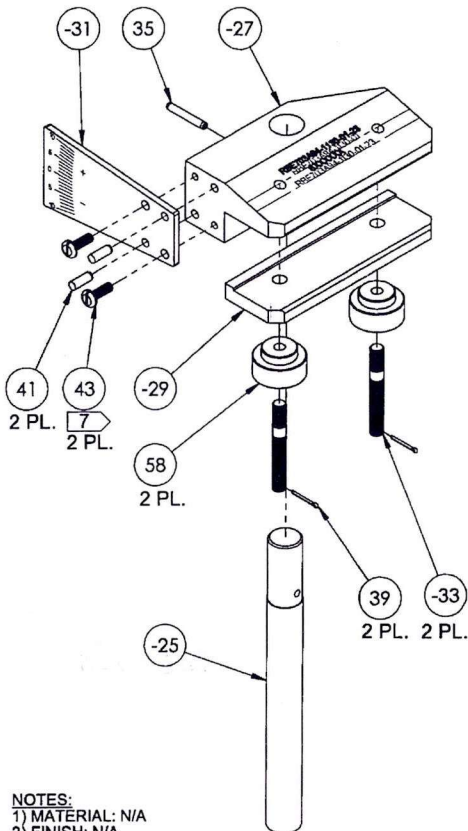
✓ S084675(7)133  
 ✓ S127539 (5) 4  
 S172745(1) "S054187  
 S143609(7) 4

| Job Allocations                    |                      |          |           |           |
|------------------------------------|----------------------|----------|-----------|-----------|
| Operation                          | Component Part       | Required | Inventory | Allocated |
| 110-Small Fab - 1                  | 6NF45/A              | 40       | 2         | 0         |
|                                    | 90353A214            | 40       | 21        | 0         |
|                                    | 91595A155            | 40       | 73        | 0         |
|                                    | 98296A882            | 20       | 215       | 0         |
|                                    | 98338A022            | 40       | 23        | 0         |
|                                    | RBE703A94-1130-01-25 | 20       | 10        | 0         |
|                                    | RBE703A94-1130-01-27 | 20       | 20        | 0         |
|                                    | RBE703A94-1130-01-29 | 20       | 10        | 0         |
|                                    | RBE703A94-1130-01-31 | 20       | 10        | 0         |
|                                    | RBE703A94-1130-01-33 | 40       | 23        | 0         |
| Part Specifications                |                      |          |           |           |
| Specifications could not be found. |                      |          |           |           |

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| ITEM # | QTY | PART #               | TITLE                                | PG |
|--------|-----|----------------------|--------------------------------------|----|
| -25    | 1   | RBE703A94-1130-01-25 | TAB ADJUSTER HANDLE                  | 10 |
| -27    | 1   | RBE703A94-1130-01-27 | TAB ADJUSTER BODY                    | 11 |
| -29    | 1   | RBE703A94-1130-01-29 | TAB ADJUSTER CLAMP                   | 12 |
| -31    | 1   | RBE703A94-1130-01-31 | TAB ADJUSTER GAUGE PLATE             | 13 |
| -33    | 2   | RBE703A94-1130-01-33 | ADJUSTER                             | 14 |
| 35     | 1   | McMaster#98296A882   | SPRING PIN Ø1/8 X 7/8                | -  |
| 39     | 2   | McMaster#98338A022   | COTTER PIN Ø3/64 X 1/2               | -  |
| 41     | 2   | McMaster#91595A155   | DOWEL PIN 4mm X 12mm                 | -  |
| 43     | 2   | McMaster#90353A214   | PAN HEAD M4 x 0.7 x 12mm             | -  |
| 58     | 2   | J.W. WINCO #6NF46A   | KNURLED NUT M6 X 1.0 DIN 6303 TYPE A | -  |



SECTION A-A

RBE703A94-1130-01-23 DEFLECTION CLIP ASSY

- NOTES:
- 1) MATERIAL: N/A
  - 2) FINISH: N/A
  - 3) HEAT TREAT: N/A
  - 4) SPEC: N/A
  - 5) BREAK ALL SHARP EDGES: N/A
  - 6) IDENTIFICATION: N/A
  - 7) APPLY LOCTITE 263 OR EQUI.

|                                                                                                                                                                                                                                                                                        |                         |                                                           |  |
|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------------------|-----------------------------------------------------------|--|
| <b>DART AEROSPACE</b> <small>Howellbury, Ontario, Canada</small>                                                                                                                                                                                                                       |                         |                                                           |  |
| <b>TITLE</b><br>DEFLECTION CLIP ASSY                                                                                                                                                                                                                                                   |                         |                                                           |  |
| DWG NO. RBE703A94-1130-01-23                                                                                                                                                                                                                                                           |                         | REV K                                                     |  |
| DESIGN BY: VM 8/28/2017                                                                                                                                                                                                                                                                | CHK: VM 11/24/2017      | 1. DIMENSIONS ARE IN INCHES<br>UNLESS OTHERWISE SPECIFIED |  |
| DRAWN BY: VM 11/24/2017                                                                                                                                                                                                                                                                | CHECKED: VM 11/30/2017  | 2. INTERPRET DIM AND TOL PER ASME Y14.5M-2009             |  |
| DATE: 11/24/2017                                                                                                                                                                                                                                                                       | APPROVED: VM 11/30/2017 | 3. DIMENSIONAL LIMITS APPLY AFTER PLATING                 |  |
| SCALE: NTS                                                                                                                                                                                                                                                                             | WEIGHT: N/A             | SHEET 9 OF 17                                             |  |
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SHOP COPY  
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 193098 MLC  
19-04-08

Entered: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. \_\_\_\_\_

Route update only ☐

|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |              |                               |
|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------|-------------------------------|
| Job: _____<br><br>Part No. _____                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         | <b>DISPOSITION</b><br><br>Rework <input type="checkbox"/><br>Scrap <input type="checkbox"/><br>Use-as-is <input type="checkbox"/> | <b>DEPARTMENT/PROCESS</b><br><br><div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/><br/>           Machining <input type="checkbox"/><br/>           Large Fab <input type="checkbox"/> </div> <div>           Cross tube <input type="checkbox"/><br/>           Small Fab <input type="checkbox"/><br/>           Finishing <input type="checkbox"/> </div> <div>           Eng. (Non-AW) <input type="checkbox"/><br/>           Prod. Eng. Coord. <input type="checkbox"/><br/>           Rec/Store/Packaging <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/><br/>           Water Jet <input type="checkbox"/><br/>           Supplier <input type="checkbox"/><br/>           Quality <input type="checkbox"/> </div> </div>                                                                                                                                                                                                                                                                      |              |                               |
| Date : <b>MAY 07 2019</b>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                | Sequence #: <b>120</b>                                                                                                            | QTY Affected : <b>1</b>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   | MRB (QS1042) |                               |
| <b>Description Work Order Deviation</b>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |                                                                                                                                   | <b>Disposition</b>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |              | <b>Completed By</b>           |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |              | <b>Lead hand / Supervisor</b> |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |              |                               |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |              | <b>QC / QA Coordinator</b>    |
| <b>Root Cause</b><br><br><div style="display: flex;"> <div style="flex: 1;">           Operator <input type="checkbox"/><br/>           Manufacturing Process <input type="checkbox"/><br/>           Equip/Tooling <input type="checkbox"/><br/>           Handling/Preservation <input type="checkbox"/><br/>           Material <input type="checkbox"/><br/>           Product Improvement <input type="checkbox"/><br/>           Process Improvement <input type="checkbox"/><br/>           Human Factors <input type="checkbox"/> </div> <div style="flex: 1;"> <input type="checkbox"/> Pressure/Forced<br/> <input type="checkbox"/> Bending<br/> <input type="checkbox"/> Crushing<br/> <input type="checkbox"/> Cracks<br/> <input type="checkbox"/> Crimp/Kink/Ripple/Wave/Twist<br/> <input type="checkbox"/> Marks/Chatter<br/> <input type="checkbox"/> Mislabeled         </div> </div> |                                                                                                                                   | <b>FAULT CATEGORY</b><br><br><div style="display: flex;"> <div style="flex: 1;"> <input type="checkbox"/> Contamination<br/> <input type="checkbox"/> Misaligned/off center<br/> <input type="checkbox"/> BOM/Route<br/> <input type="checkbox"/> Broken/Damage/Defect<br/> <input type="checkbox"/> Incomplete/Unclear Instructions<br/> <input type="checkbox"/> Drill Holes<br/> <input type="checkbox"/> Fit/Function         </div> <div style="flex: 1;"> <input type="checkbox"/> Power Loss/Surge<br/> <input type="checkbox"/> Folio/Program<br/> <input type="checkbox"/> Grain Direction<br/> <input type="checkbox"/> Weld<br/> <input type="checkbox"/> Wrong Stock Pulled<br/> <input type="checkbox"/> Out of Sequence<br/> <input type="checkbox"/> Off-set/Set-up         </div> <div style="flex: 1;"> <input type="checkbox"/> Positioned Wrong<br/> <input type="checkbox"/> Outside Tolerance<br/> <input type="checkbox"/> Drawing<br/> <input type="checkbox"/> Finish<br/> <input type="checkbox"/> Part Lost/Missing<br/> <input type="checkbox"/> Misread         </div> </div> |              |                               |
| Other/Details:                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |              |                               |